

Work Order ID 161392

Monday, May 15, 2017 12:42:47 PM

161392

Page 1

Item ID: D3566-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Center Aft

Start Date: 5/15/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/16/2017 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3566	Rev C								

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.81

FLOW CNC Waterjet

1-Cut as per Dwg D3566 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary2805/17/16

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.20

Quality Control

2805/17/16

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.40

Quality Control

28DAS
38
9-89

MAY 17 2017

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130						28	DAS 6		
Packaging	Memo	0.20					9-89		MAY 18 2017
Packaging	LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									17/5/18
QC	Memo	2.00							
Quality Control									

DAS
21
9-89

MAY 18 2017

Picklist Print

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Work Order ID: 161392

161392

Parent Item: D3566-5

D3566-5

Parent Item Name: Gasket Center Aft

Start Date: 5/15/2017

Required Date: 5/16/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	231.2769	1.06	23.55556			

MNEO60S 063

NEOPRENE SHEET 0.063

No.110750002 NEOPRENE DURO 60+/-5 "A" 1/16" IMPORT GR PT

**

05/17/16

Location	Loc Qty	Loc Code
GA	8.2149	
M131990	8.2149	
MAT	31.8	
M135551	31.8	
MAT052	191.262	
M136565	16.762	
M137313	174.5	

30

DART AEROSPACE LTD		Work Order: 161392
Description: Gasket		Part Number: D3566-5
Inspection Dwg: D3566 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

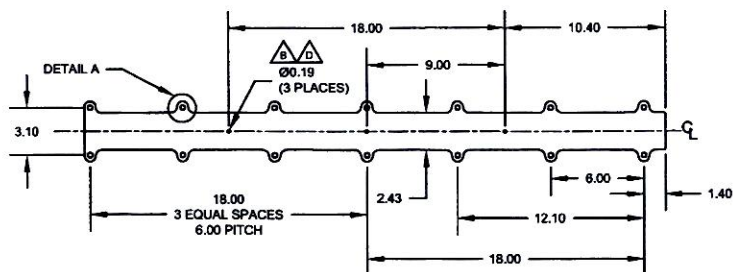
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50	1		Tape	
43.50	+/-0.030	43.50	1		V: ac. 02	
5.50 Pitch	+/-0.030	5.50	1			
2.50	+/-0.030	2.50	1			
2.43	+/-0.030	2.43	1			
3.10	+/-0.030	3.10	1			
2.50	+/-0.030	2.50	1			
0.30	+/-0.030	.30	1			
0.30	+/-0.030	.30	1			
0.063	+/-0.010	.063	1			
6.75	+/-0.030	6.75	1			
10.00	+/-0.030	10.00	1			
20.00	+/-0.030	20.00	1			
30.00	+/-0.030	30.00	1			
Ø0.19	+/-0.030	Ø.19	1			

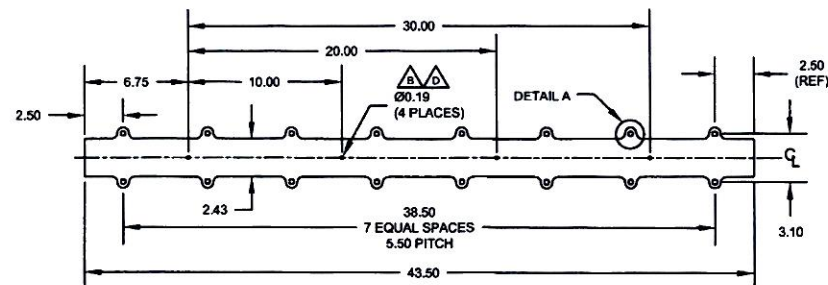
Measured by: ac	Audited by: DAS 38 9-89	Prototype Approval:	N/A
Date: 17/05/16	Date: MAY 17 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.06	Ø0.188 dimension removed	KJ/JLM	
D	08.01.16	Dwg Rev updated	KJ/EC/DD	

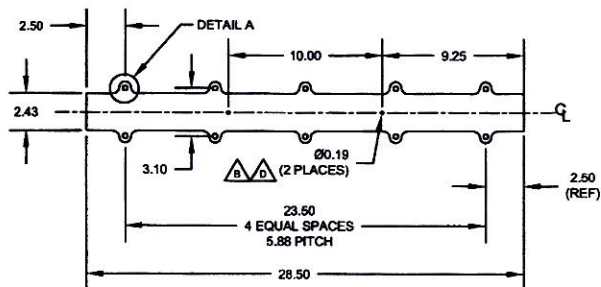
8 7 6 5 4 3 2 1



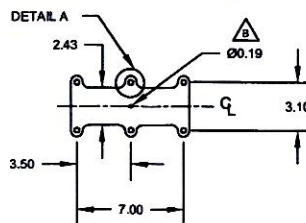
D3566-1 GASKET



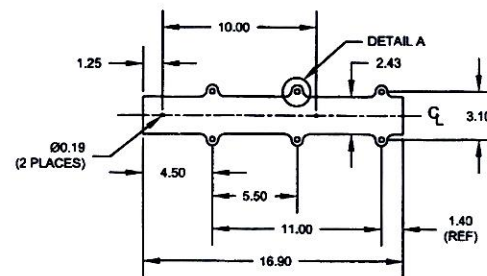
D3566-5 GASKET



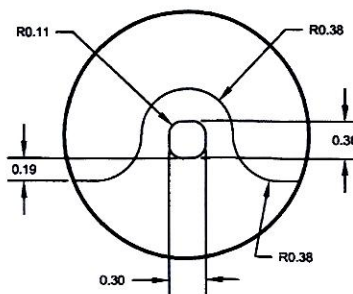
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



DETAIL A
SCALE 1:1

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.38 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT C

RELEASED

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3566
REV. C
SHEET 1 OF 1
TITLE GASKET
SCALE 1:8

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